

Date: Monday, 11/05/2009 1:20:50 PM
 User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|--|----------|------------------|------------------|---------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : FRAME | | |
| Job Number | : 47841 | | | Part Number | : D225217 | | |
| Estimate Number | : 13827 | | | Drawing Number | : D2252 REV G | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 11/05/2009 | S.O. No. | : | Drawing Revision | : G | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : LARGE FAB ASSY | Due Date | : 22/05/2009 | | |
| Previous Run | : 46827 | | | Qty: | 8 | | |
| Written By | : | | | Um: | Each | | |
| Checked & Approved By | : JUL 09.05.11 | | | 12x | | | |
| Comment | : Est Rev:A 09.03.18 New Issue EC verified by:DD | | | | | | |

Additional Product

Job Number:



| | | |
|--|-----------------------|---|
| Seq. #: | Machine Or Operation: | Description : |
| 1.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W M110839 = 2.91f Scrap end Bar M111148 = 1.33f |
| Comment: Qty.: 1.7220 f(s)/Unit Total : 6.8880 f(s) * 304 SQ Tube .75x.75x.065W batch: M111148 → 5x M110839 → 7x 84 09/05/13 | | |
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
| Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2252 *****angle is 53***** 2- Deburr and remove identification markings on tube | | |
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| Comment: INSPECT WORK TO CURRENT STEP 84 09/05/13 (X12) | | |
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Baskets | | |
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| Comment: FINAL INSPECTION/W/O RELEASE 09/05/13 (12) | | |
| Job Completion | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

| ITEM | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|------------------|
| 1 | X | | D2252-041 | BASKET ASSEMBLY |
| 3 | | X | D2252-043 | LID ASSEMBLY |
| 7 | 2 | 2 | D2221-1 | RIB |
| 8 | 5 | | D2235-1 | RIB |
| 9 | 2 | 2 | D2252-1 | FRAME |
| 10 | | 2 | D2252-7 | FRAME |
| 11 | 1 | | D2252-9 | FRAME |
| 12 | 1 | | D2252-11 | FRAME |
| 13 | 1 | | D2252-13 | FRAME |
| 14 | 1 | | D2252-15 | FRAME |
| 15 | 4 | | D2252-17 | FRAME |
| 16 | | 1 | D2252-23 | FRAME |
| 17 | 2 | | D2253-1 | LUG |
| 18 | 2 | | D2254 | GUSSET |
| 19 | 1 | 1 | D2327-3 | BUSHING |
| 20 | | 1 | D2329 | LABEL PLATE |
| 21 | 4 | 2 | D2581 | MOUNTING CHANNEL |
| 22 | | 2 | D2989-19 | RIB |
| 23 | 3 | | D3748-1 | HINGE HALF |
| 24 | | 3 | D3749-1 | HINGE HALF |

G

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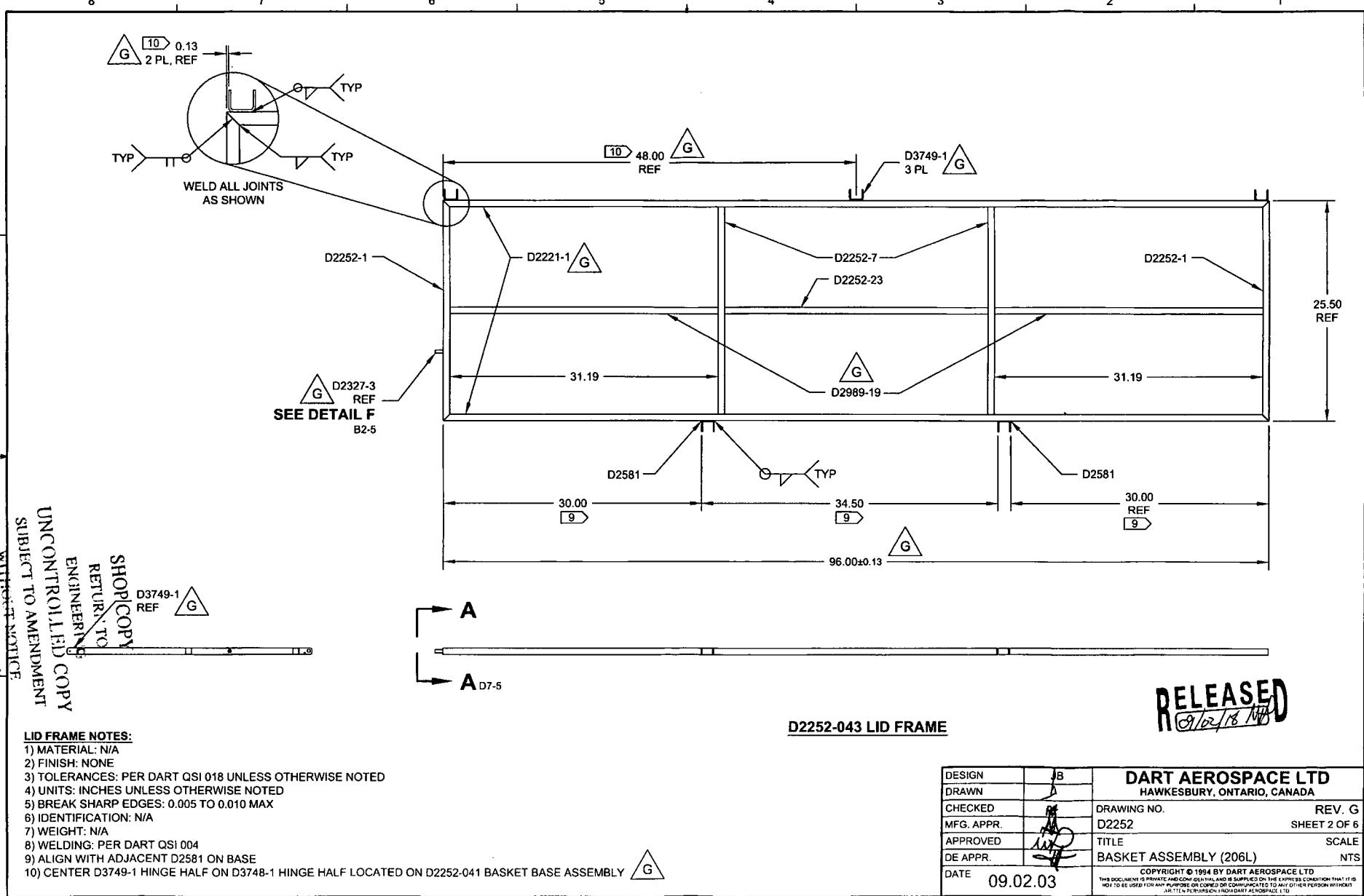
G

RELEASED
8/02/18 PM

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NO. 4781
WORK ORDER
WITHOUT NOTICE

NOTES:
 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
 REF. DART SPEC M304TS0.750W.065
 2) MESH MATERIAL: 3/4-16F EXPANDED SS
 REF DART SPEC M304EX0.75-16F
 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A
 8) WEIGHT: N/A
 9) WELDING: PER DART QSI 004

| | | | |
|------------|---|--|----------|
| G | ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006. | MB | 09.02.03 |
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060. | AJS | 08.08.11 |
| E | INCORPORATED D1 & D2. ADDED D2231-1/3 & D2252-19. | MB | 05.11.10 |
| D | MODIFIED LATCH, D2581 WAS D2255-3 | BK | 99.09.14 |
| C | RE-DRAWN | BK | 95.12.11 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. REV. G D2252 | |
| CHECKED | | SHEET 1 OF 6 | |
| MPG. APPR. | | TITLE SCALE BASKET ASSEMBLY (206L) NTS | |
| APPROVED | | DATE 09.02.03 | |
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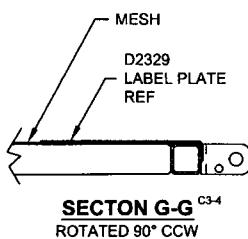


LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

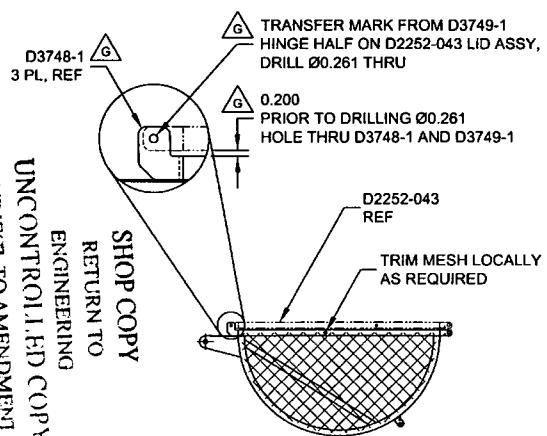
NO. *4788*
WORK ORDER
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REF *D3749-1 G*
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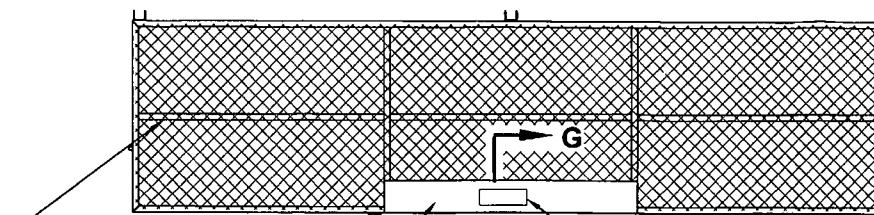
SECTON G-G C3-4
ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



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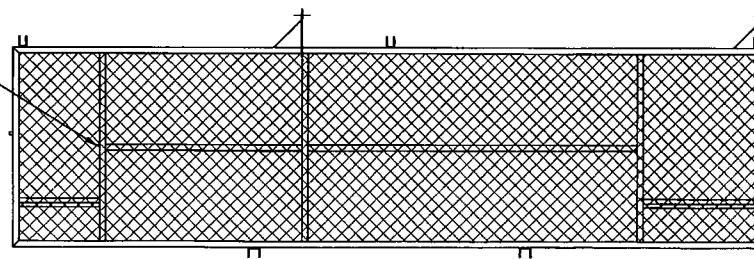
ASSEMBLY NOTES:
1) MATERIAL: SEE SHEET 1 FOR MESH
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 U
4) UNITS: INCHES UNLESS OTHERWISE
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004



D2329 LABEL PLATE
CENTER ON THE
BASKET LID

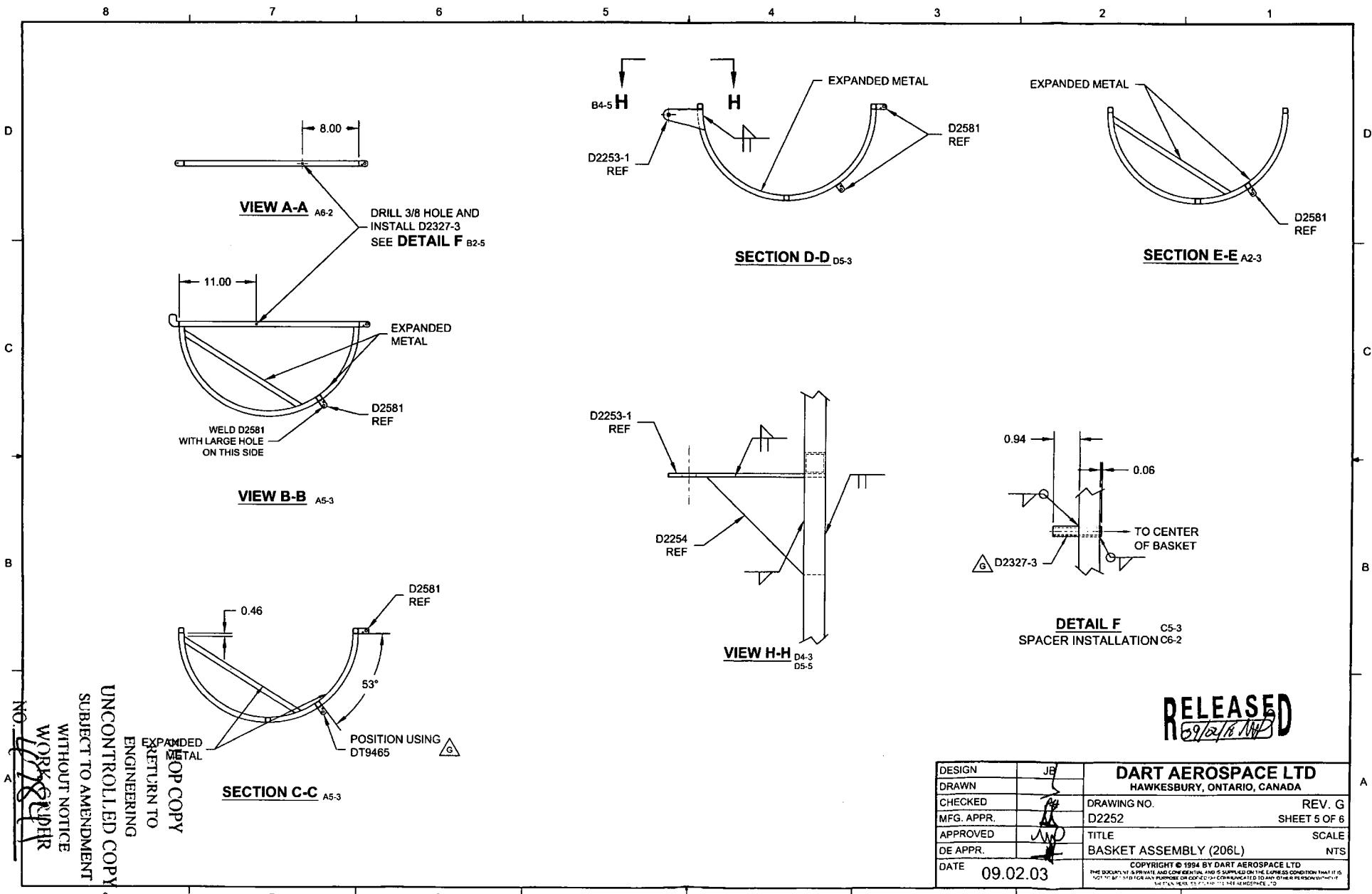
REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY

| | | | | |
|------------|----------|--|--------------|--|
| DESIGN | JB | DART AEROSPACE LTD | | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | | DRAWING NO. | REV. G | |
| MFG. APPR. | | D2252 | SHEET 4 OF 6 | |
| APPROVED | AND | TITLE | SCALE | |
| DE APPR. | | BASKET ASSEMBLY (206L) | NTS | |
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| MFG. APPR. | | SHEET 5 OF 6 | |
| APPROVED | | TITLE BASKET ASSEMBLY (206L) | |
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